

## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	ER410
<b>Product Code:</b>	RW 410
<b>Werkstoff No.:</b>	-
<b>MIG Certification:</b>	-
<b>TIG Certification:</b>	-

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
13	ER410	SS410	ER410

### DESCRIPTION AND APPLICATIONS

RW 410 / RW 410NIMO is a welding wire class for martensitic or ferritic-martensitic stainless steels and overlay applications on carbon or low-alloy steels. RW 410 is used on similar-composition metals or weld overlays where corrosion, erosion and wear resistance are required. RW 410NIMO is suitable for martensitic and ferritic-martensitic stainless steels such as 410/410S/405 in applications including hydro turbines. Preheating and post-weld heat treatment may be required for ductility, for RW 410NIMO, post-weld heat treatment should not exceed 620°C.

### TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
<b>C</b>	-	0,12
<b>Mn</b>	-	0,60
<b>Si</b>	-	0,50
<b>S</b>	-	0,020
<b>P</b>	-	0,030
<b>Cr</b>	12,0	13,5
<b>Ni</b>	-	0,6
<b>Mo</b>	-	0,75
<b>Cu</b>	-	0,40
<b>N</b>	-	-
<b>Nb</b>	-	-
<b>Ti</b>	-	-

### DIAMETER

<b>MIG sizes</b>	0,8   0,9   1,0   1,14   1,2   1,6
<b>TIG sizes</b>	0,8   0,9   1,0   1,2   1,6   2,0   2,4   3,2   4,0
<b>SAW sizes</b>	1,6   2,0   2,4   3,2   4,0

### PACKAGING

<b>MIG</b>	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
<b>TIG</b>	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
<b>SAW</b>	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

Note: Safety Data Sheet is available on request.

## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	ER410NiMo
<b>Product Code:</b>	RW 410NIMO
<b>Werkstoff No.:</b>	-
<b>MIG Certification:</b>	-
<b>TIG Certification:</b>	-

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
13 4	ER410NiMo	SS410NiMo	ER410NiMo

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### TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
<b>C</b>	-	0,05
<b>Mn</b>	-	1,00
<b>Si</b>	-	0,50
<b>S</b>	-	0,020
<b>P</b>	-	0,030
<b>Cr</b>	11,0	12,5
<b>Ni</b>	4,0	5,0
<b>Mo</b>	0,40	0,70
<b>Cu</b>	-	0,30
<b>N</b>	-	-
<b>Nb</b>	-	-
<b>Ti</b>	-	-

### DIAMETER

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<b>TIG sizes</b>	0,8   0,9   1,0   1,2   1,6   2,0   2,4   3,2   4,0
<b>SAW sizes</b>	1,6   2,0   2,4   3,2   4,0

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